

ABSTRACT

A molten resin P is filled into a cavity 17 through a film gate 17a provided a ring shape in a position 5 corresponding with an outer peripheral edge of the outside surface 7a2 of the seal portion 7a. The molded product removed from the molding die is completed by removing the residual resin gate portion 7d. A gate removal portion 7d1 formed by removing the resin gate portion appears as a 10 narrow ring shape at the outer peripheral edge of the outside surface 7a2 of the seal portion 7a.